

ABSTRACT

A clamping device 2 is provided with a hydraulic cylinder 7 for biasing a collet member 5 upward via a collet supporting member 6 and driving a pull rod 4 downward. A piston member 30 has a greater pressure receiving area than the collet supporting member 6 in the circular hydraulic chamber 31 of the hydraulic cylinder 7. Therefore, the hydraulic cylinder 7 can drive the pull rod 4 downward while the collet member 5 is biased upward. Meanwhile, the collet 5a of the collet member 5 is resiliently deformed in a diametrically expanding manner to engage in the vertical bore 1b of a workpiece 1 while slightly moving downward, ensuring a secure locking of the workpiece 1 to a workpiece receiving surface 3a.